

Work Order ID 138743

138743

Page 1

Wednesday, November 11, 2015 8:07:55 AM

Item ID: D4713-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 11/23/2015 Start Qty: 8.00

8

Cust Item ID:

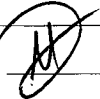
Required Date: 12/10/2015 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-10-11

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4713	A

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

TURN AS PER DWG

FOLIO REV: AA

DWG REV: A

DEBURR

8

Ø

DAS
40
9-89

15/11/18

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

8

Ø

DAS
40
9-89

15/11/18

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Page 2

Item ID: D4713-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 11/23/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/10/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						8	0		JFC 2015-11-18
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>S4D1</u>	0.00							
130						8	MLJ	15-11-18	
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						MLJ		NOV 19 2015	
QC	Memo	0.00							
Quality Control									

MLJ NOV 19 2015

Picklist Print

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Work Order ID: 138743

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Parent Item: D4713-1

D4713-1

Parent Item Name: Spacer

Start Date: 11/23/2015

Required Date: 12/10/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 12-09-11 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.2500		Purchased			No	100	f	15.2940	0.03125	0.263158			DAS
MDFI RINR1 2500													40
DEL RIN ROUND BAR 1.25" color: black												15/11/18	9-89

Location

Loc Qty

Loc Code

MAT

8

m133285

8

MAT039

7.294

→ m131782

3.294

m133241

4

DQA: _____ Date: _____

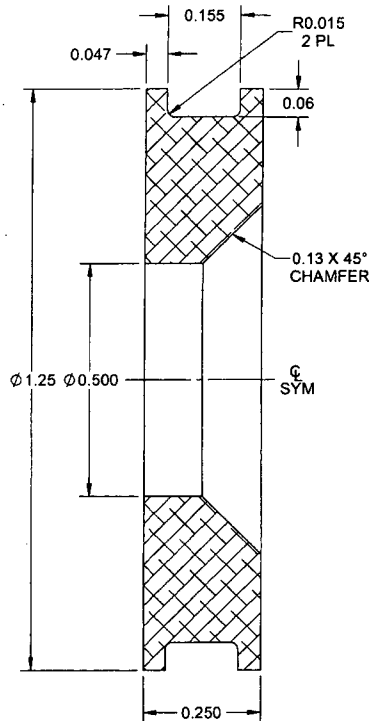


WORK ORDER NON-CONFORMANCE / UPDATE

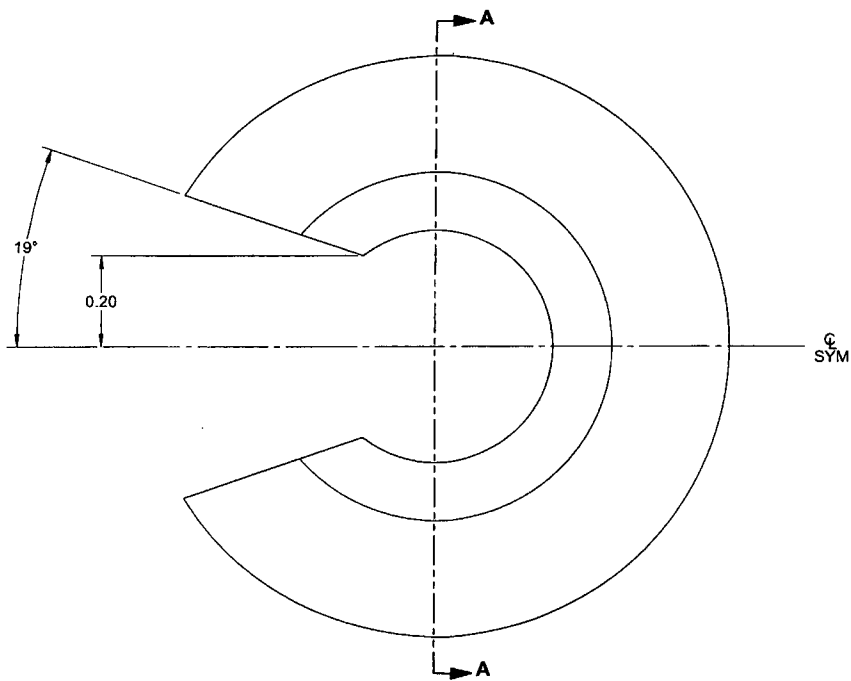
QA Closed: _____ Date: _____

Work Order update only ☐

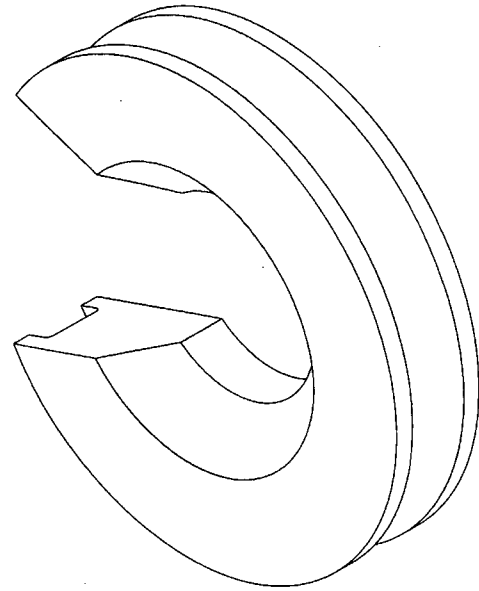
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 16.6%;">Skid-tube ☐</td> <td style="width: 16.6%;">Cross tube ☐</td> <td style="width: 16.6%;">Water Jet ☐</td> <td style="width: 16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
										QC / QA Coordinator Approval																																																					
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER :																																																															



SECTION A-A



D4713-1 SPACER



- NOTES:**
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, REF DART SPEC. M-DELRIN-R1.250
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.01 lbs

Handwritten: 15.11-11
138743

Handwritten: 2012-09-24
RELEASED

A		NEW ISSUE		AP	12.09.12
REV.		DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA			
DRAWN	AP				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4713	SHEET 1 OF 1		
APPROVED		TITLE	SCALE		
DE APPR.		SPACER	NTS		
DATE		COPYRIGHT © 2012 BY DART AEROSPACE LTD			
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